

Work Order ID 52128

September 16, 2009 2:27:37 PM



Page 1

Item ID: D2917-2

Accept



Setup Start



Revision ID: B

Item Name: Saddle RH

Stop



Start Date: 09/30/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: UMK

Date: 09-09-16 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2917

Rev B

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

0.00

Memo

- Program batch number Machine Step No 1 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet
- Machine Step No 2 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet
- Machine Step No.3 as per Folio

ant 09/09/28
88 09/09/29

10 0

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

0.00

Memo

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

ant 09/09/28
88 09/09/29

10 0

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

ant 09/09/28

10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52128

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Page 2

Item ID: D2917-2

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Setup Start



Revision ID: B

Stop



Item Name: Saddle RH

Start Date: 09/30/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

09.09.29

10

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

09/09/30

X10

0

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

09/09/30

X10

0

Powder Coating

START TIME: 1:00pm FINISH TIME: 3:20pm

OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52128

September 16, 2009 2:27:37 PM

Page 3

Item ID: D2917-2

Accept

Revision ID: B

Item Name: Saddle RH

Start Date: 09/30/2009 Start Qty: 10.00

Required Date: 10/05/2009 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

09/10-1

0.00

(10)

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

Packaging

0.00

09/10/01 (10)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

0.00

09/10/01

ME

09-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 16, 2009 2:27:37 PM

Page 1

Work Order ID: 52128



Parent Item: D2917-2RevB



Parent Item Name: Saddle RH

Start Date: 09/30/2009

Required Date: 10/05/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D6102-010RevD		Manufactured	No			100	Each	6.0000	10.0000			
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Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

6

51423

6

352067

10

mt 09/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 52128
Description: Saddle RH	Part Number: D2917-2
Inspection Dwg: D2917 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.175	0.205		.190	.190	.190	.189		
B	0.090	0.110		.095	.099	.103	.096		
C	0.250	0.270		.258	.259	.258	.258		
D	1.599	1.619		1.609	1.608	1.607	1.608		
E	0.180	0.220		.180	.180	.180	.180		
F	0.277	0.297		.281	.282	.282	.284		
G	1.385	1.400		1.389	1.390	1.390	1.388		
H	3.170	3.230		3.190	3.199	3.200	3.200		
I	0.175	0.217		.175	.175	.176	.179		
J	0.470	0.530		.500	.500	.506	.500		
K	1.498	1.508		1.502	1.500	1.504	1.500		
L	4.436	4.446		4.438	4.440	4.441	4.443		
M	0.257	0.262	DT8683	.259	.259	.259	.259		
N	1.225	1.235		1.227	1.228	1.228	1.228		
O	1.103	1.113		1.108	1.108	1.108	1.106		
P	0.470	0.530		.500	.502	.500	.500		
Q	0.438	0.443	DT8682	.440	.440	.440	.440		
R	0.490	0.510		.500	.502	.500	.503		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.203	.205	.205	.205		
W	1.990	2.010		2.002	2.005	2.005	2.002		
X	0.760	0.765		.760	.760	.761	.761		
Y	0.307	0.312		.310	.310	.311	.311		
Z	0.615	0.635		.628	.635	.628	.627		
AA	0.177	0.197		.184	.186	.186	.186		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	cmf
Date:	09/09/28

Audited by:	cmf
Date:	09.09.29

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 52125
Description: Saddle RH		Part Number: D2917-2
Inspection Dwg: D2917 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	18	16	17	18		
A	0.175	0.205		.187	.188	.188	.188		
B	0.090	0.110		.090	.090	.090	.090		
C	0.250	0.270		.257	.257	.258	.258		
D	1.599	1.619		1.607	1.608	1.608	1.609		
E	0.180	0.220		.180	.180	.180	.180		
F	0.277	0.297		.283	.282	.281	.283		
G	1.385	1.400		1.387	1.388	1.396	1.389		
H	3.170	3.230		3.200	3.200	3.200	3.200		
I	0.175	0.217		.177	.177	.177	.176		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.503	1.502	1.501	1.501		
L	4.436	4.446		4.442	4.444	4.441	4.442		
M	0.257	0.262	DT8683	.259	.259	.259	.259		
N	1.225	1.235		1.231	1.229	1.228	1.230		
O	1.103	1.113		1.106	1.106	1.106	1.107		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.440	.440	.440	.440		
R	0.490	0.510		.503	.503	.504	.500		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.001	8.001	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.205	.205	.205	.205		
W	1.990	2.010		2.003	2.003	2.005	2.004		
X	0.760	0.765		.761	.761	.760	.760		
Y	0.307	0.312		.311	.311	.310	.310		
Z	0.615	0.635		.629	.627	.627	.625		
AA	0.177	0.197		.186	.186	.184	.188		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>cmf</i>
Date:	09/09/28

Audited by:	<i>MP</i>
Date:	09.09.29

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	<i>MP</i>

DART AEROSPACE LTD		Work Order: 52128
Description: Saddle RH		Part Number: D2917-2
Inspection Dwg: D2917 Rev. A1		Page 1 of 1

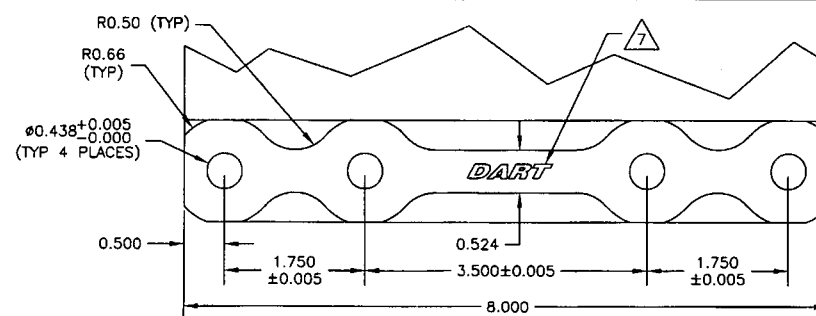
Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1/9	2/10	1/8	1/8		
A	0.175	0.205		.187	.187				
B	0.090	0.110		.090	.090				
C	0.250	0.270		.258	.253				
D	1.599	1.619		1.610	1.610				
E	0.180	0.220		.180	.180				
F	0.277	0.297		.283	.283				
G	1.385	1.400		1.389	1.389				
H	3.170	3.230		3.200	3.200				
I	0.175	0.217		.180	.180				
J	0.470	0.530		.500	.500				
K	1.498	1.508		1.501	1.501				
L	4.436	4.446		4.442	4.442				
M	0.257	0.262	DT8683	.259	.259				
N	1.225	1.235		1.229	1.229				
O	1.103	1.113		1.106	1.106				
P	0.470	0.530		.500	.500				
Q	0.438	0.443	DT8682	.440	.440				
R	0.490	0.510		.500	.500				
S	1.745	1.755		1.750	1.750				
T	7.990	8.010		8.000	8.000				
U	3.495	3.505		3.500	3.500				
V	0.175	0.205		.205	.205				
W	1.990	2.010		2.003	2.000				
X	0.760	0.765		.760	.760				
Y	0.307	0.312		.310	.310				
Z	0.615	0.635		.625	.625				
AA	0.177	0.197		.187	.187				
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	anf
Date:	09/09/28 / 09/09/29

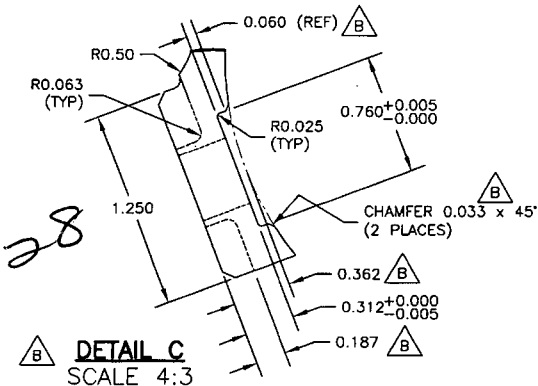
Audited by:	AP
Date:	09.09.29

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	



D2917-1 LH SADDLE (SHOWN)
D2917-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 - 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



07.07.31 ~~4~~

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	07.06.26	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES	
A	04.05.31	NEW ISSUE	
DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D2917	REV. 6 SHEET 1 OF 8
DATE 07.06.26		TITLE SADDLE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries